

Date: Thursday, 11/06/2009 1:59:26 PM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206 SADDLE, INBOARD, LEFT SIDE	
Job Number	48516		Part Number	D26621	
Estimate Number	11771		Drawing Number	D2662 REV D	
P.O. Number			Project Number	N/A	
This Issue	11/06/2009	S.O. No.	Drawing Revision	D	
Prsht Rev.	NC	Type	Material		
First Issue	/ /	MACHINED PARTS	Due Date	18/06/2009	Qty: 6 Um: Each
Previous Run					
Written By	<i>Jean-Luc Menard</i>				
Checked & Approved By					
Comment	Est: C 00.06.22 Removed P/O for powder coat EC Est Rev:D As per Rev D 07-03-19 JLM				

Additional Product					
<p>Job Number: </p> <p>Seq. #: 1.0 Machine Or Operations: D6101001 Description: Saddle Billet </p> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: 7075-T7351.1 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No:  09/06/14</p> <p>2.0 HAAS HAAS CNC VERTICAL MACHINING #1 </p> <p>Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. Inspect part number and batch number are programmed correctly. Fixturing Inspection last completed _____ by _____ Machine Step No 1 of Folio and inspect per attached Dimension Sheet Machine Step No 2 of Folio and inspect per attached Dimension Sheet Machine Step No 3 of Folio and inspect per attached Dimension Sheet Machine Step No 4 of Folio and inspect per attached Dimension Sheet Deburr 09/06/14</p> <p>3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE </p> <p>Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet</p>					

Date: Thursday, 11/06/2009 1:59:26 PM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE, INBOARD, LEFT SIDE

Job Number: 48516

Part Number: D26621

Job Number:



Seq. #: Machine Or Operation:

Description:

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECT: 01/01/2011ELEA: DA

DART AEROSPACE LTD	Work Order:	<i>49516</i>
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140							
B	0.100	0.140							
C	1.125	1.145							
D	0.615	0.685							
E	0.240	0260							
F	1.313	1.343							
G	0.210	0.230							
H	0.100	0.180							
I	2.470	2.510							
J	1.565	1.585							
K	0.235	0.240							
L	0.100	0.120							
M	0.990	1.010							
N	0.510	0.515							
O	5.990	6.010							
P	1.245	1.255							
Q	2.495	2.505							
R	0.313	0.318							
S	0.315	0.322							
T	2.495	2.505							
U	1.357	1.367							
V	0.787	0.807							
W	0.540	0.560							
X	1.674	1.684							
Y	0.257	0.262							
Z	0.912	0.932							
AA	0.490	0.510							
AB	0.178	0.198							
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<i>JLM</i>
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>JLM</i>

DART AEROSPACE LTD		Work Order: <i>48516</i>
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140							
B	0.100	0.140							
C	1.125	1.145							
D	0.615	0.685							
E	0.240	0260							
F	1.313	1.343							
G	0.210	0.230							
H	0.100	0.180							
I	2.470	2.510							
J	1.565	1.585							
K	0.235	0.240							
L	0.100	0.120							
M	0.990	1.010							
N	0.510	0.515							
O	5.990	6.010							
P	1.245	1.255							
Q	2.495	2.505							
R	0.313	0.318							
S	0.315	0.322							
T	2.495	2.505							
U	1.357	1.367							
V	0.787	0.807							
W	0.540	0.560							
X	1.674	1.684							
Y	0.257	0.262							
Z	0.912	0.932							
AA	0.490	0.510							
AB	0.178	0.198							
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

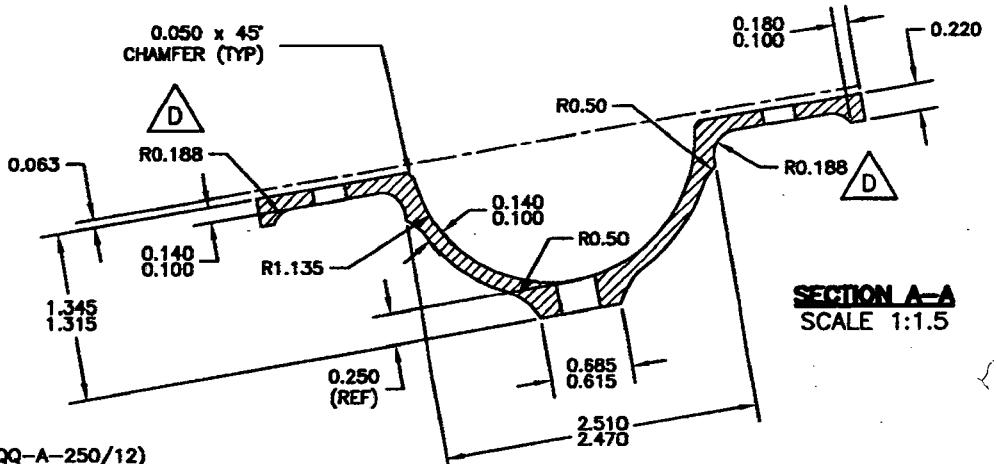
DART

DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASER

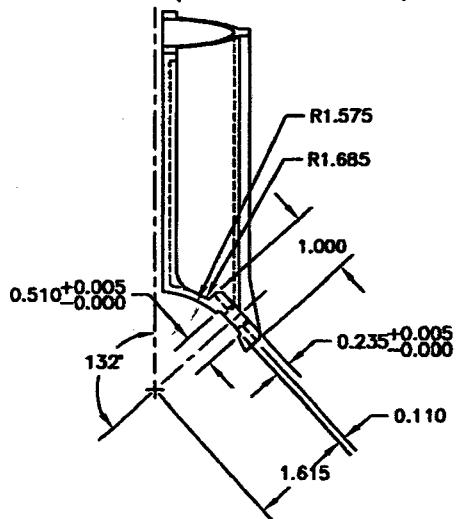
07.02.12 off

07.02.12 of

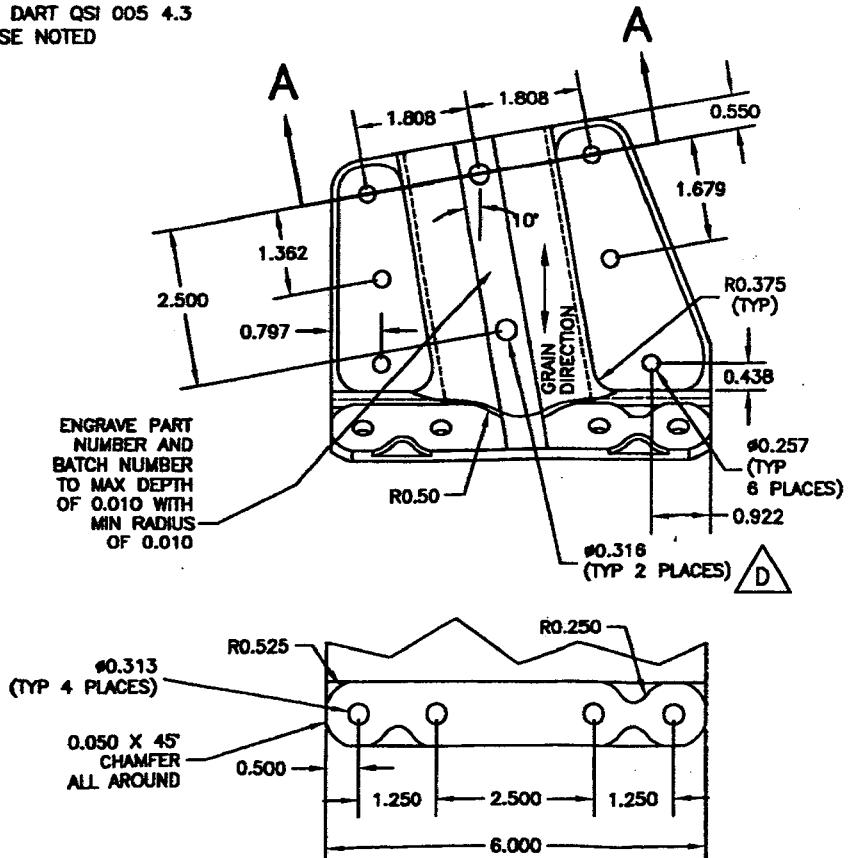


NOTES:-

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

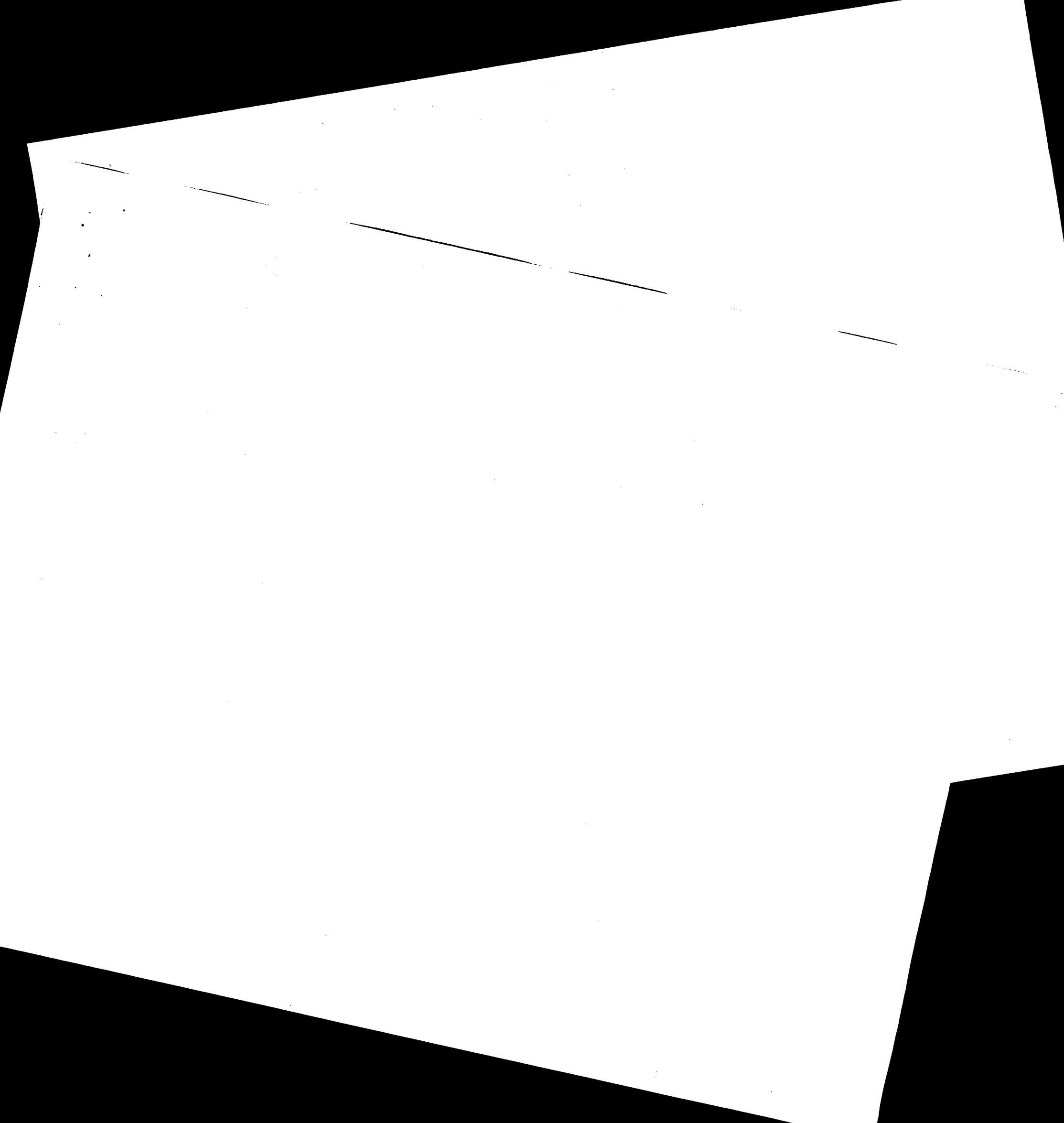


D2862-1_SADDLE_INSIDE



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



Date: - Wednesday, 12/02/09 1:14:57 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 48516	Customer	Dart Helicopters Services LLC.					
Estimate Number	: 11771	DWG Name	206 SADDLE, INBOARD, LEFT SIDE					
Purchase Order #	:	Part Number	D26621					
Complete Date	: / / : : AM	DWG Number	D2662 REV D					Rev. : D
DUEDATE	ORDERED	DELIVERED						
6/18/09	6	0						
2.0 HAAS1	<i>Internal Operation</i>							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
6/15/09	FOUR01: Fournier, Sebastien	Run	0.000	2.53	\$44.65	2.53	99.57	
6/17/09	FORT01: Fortin, Mathieu	Run	0.000	0.40	\$7.06	0.80	31.49	
Subtotal:	QTD:	0 CTD:	0	2.93	\$182.77			
		Machine Time:	3.33	\$131.06				
		Labor:	2.93	\$51.71				
		Sub-contract (external Op.):		\$0.00				
		INVENTORY ITEM:		\$0.00				
		SUB-COMPONENT (SUB-JOB):		\$0.00				
Total:					\$182.77			
		COST PER UNIT:			\$182.77			